

1/31

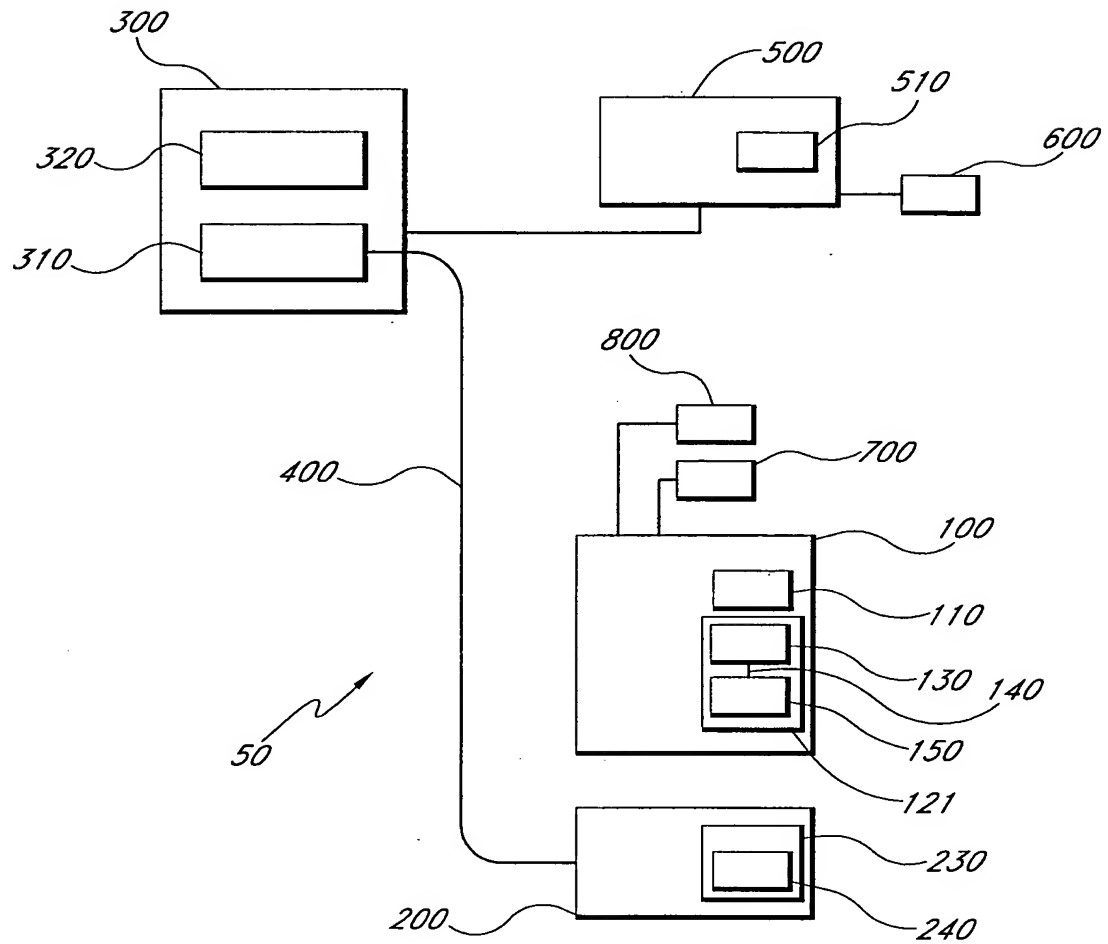


FIG. 1

2/31

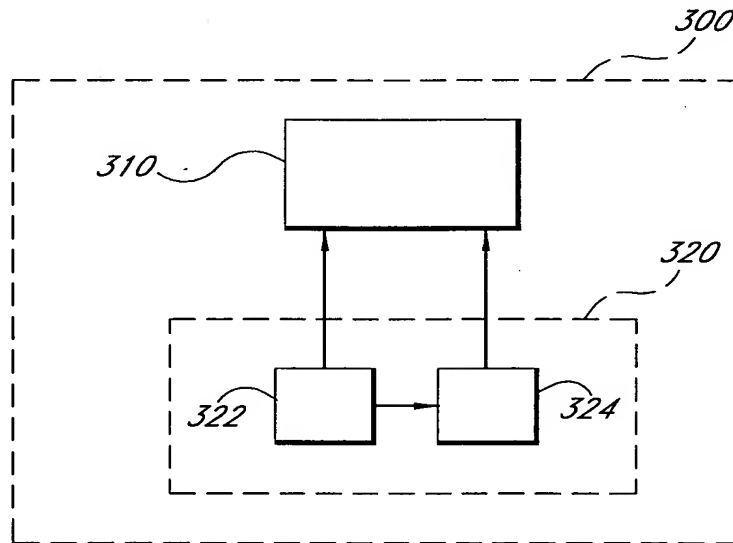


FIG. 2

3/31

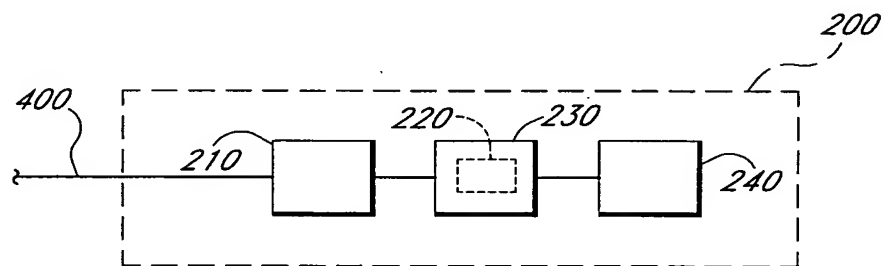


FIG. 3A

4/31

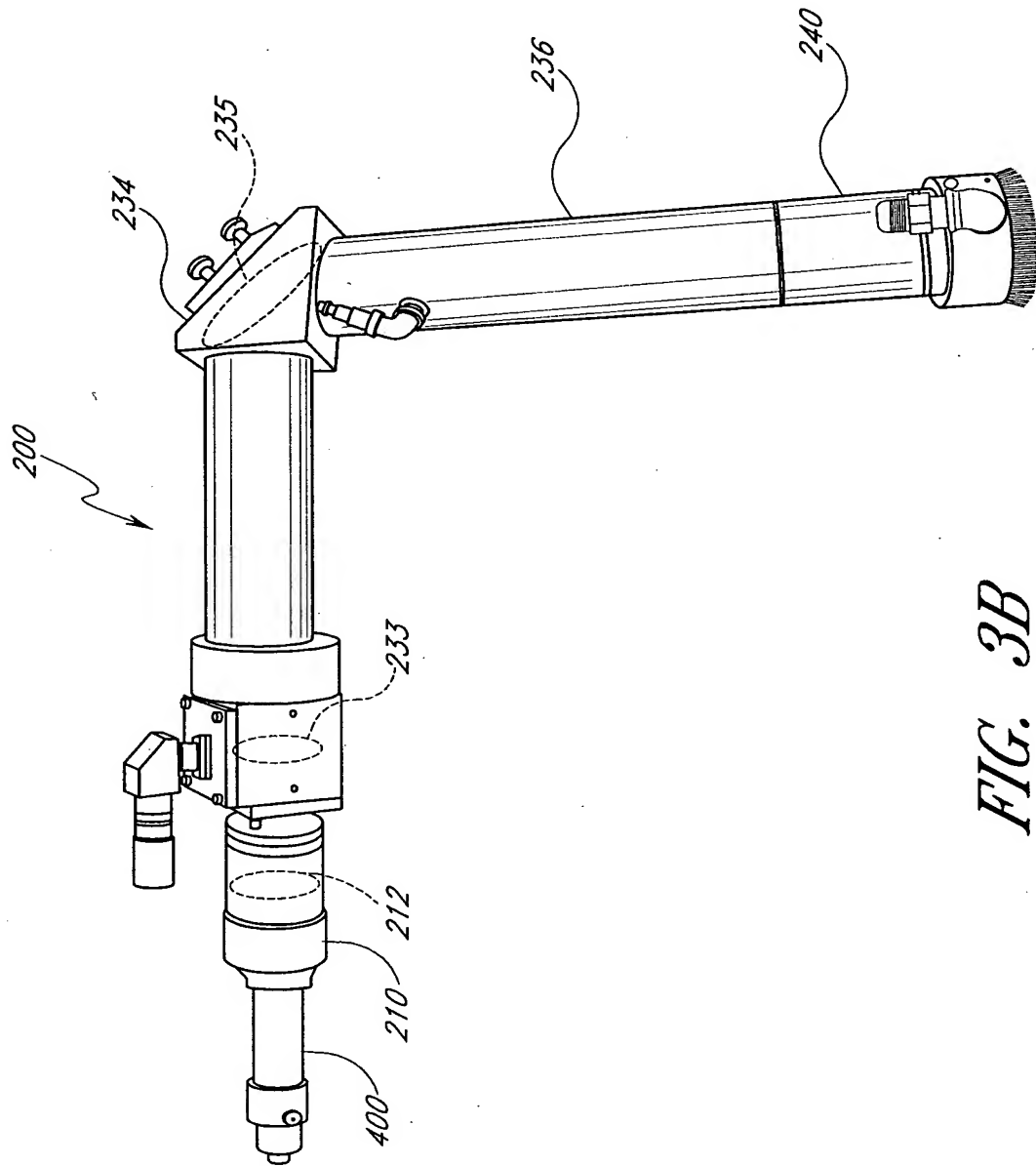


FIG. 3B

5/31

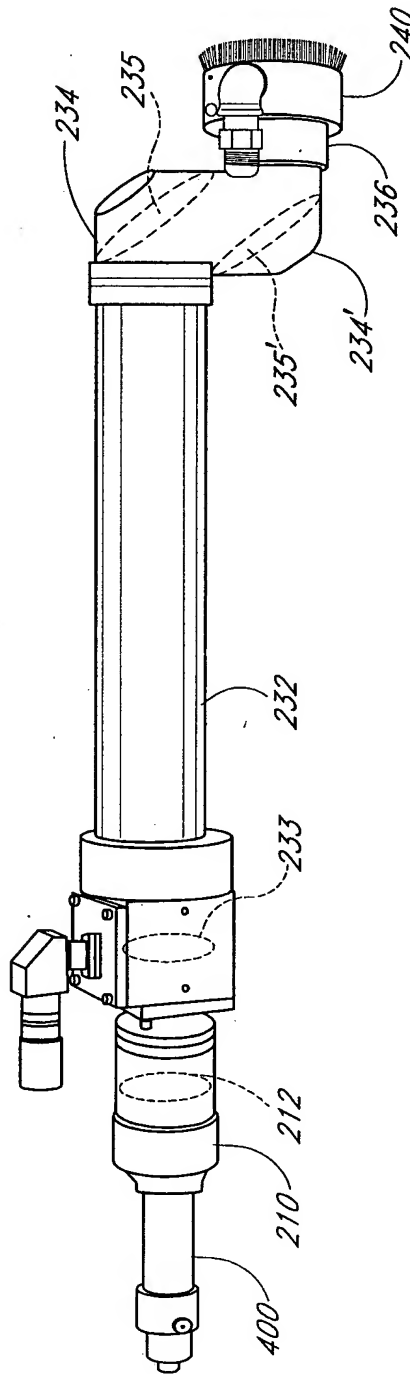


FIG. 3C

6/31

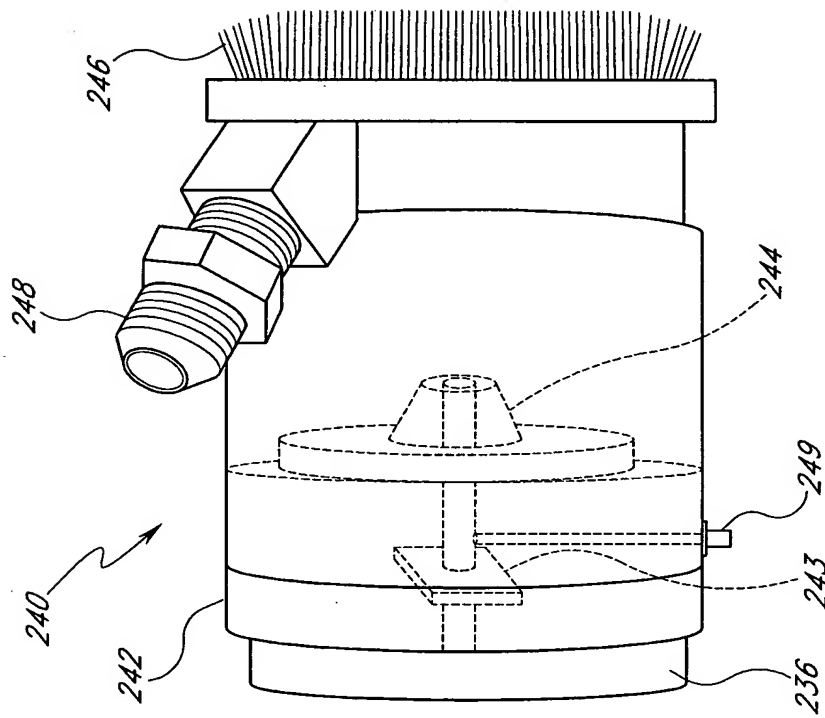


FIG. 4

7/31

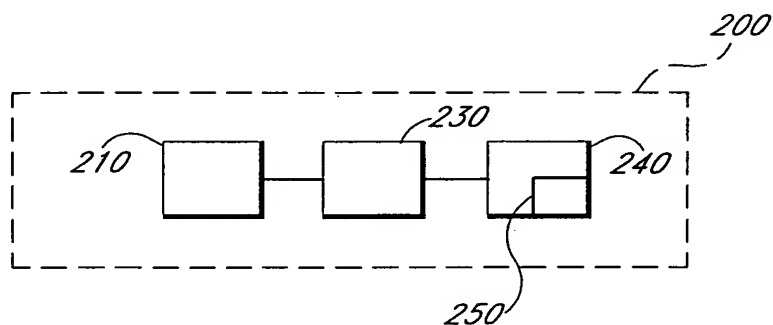


FIG. 5

8/31

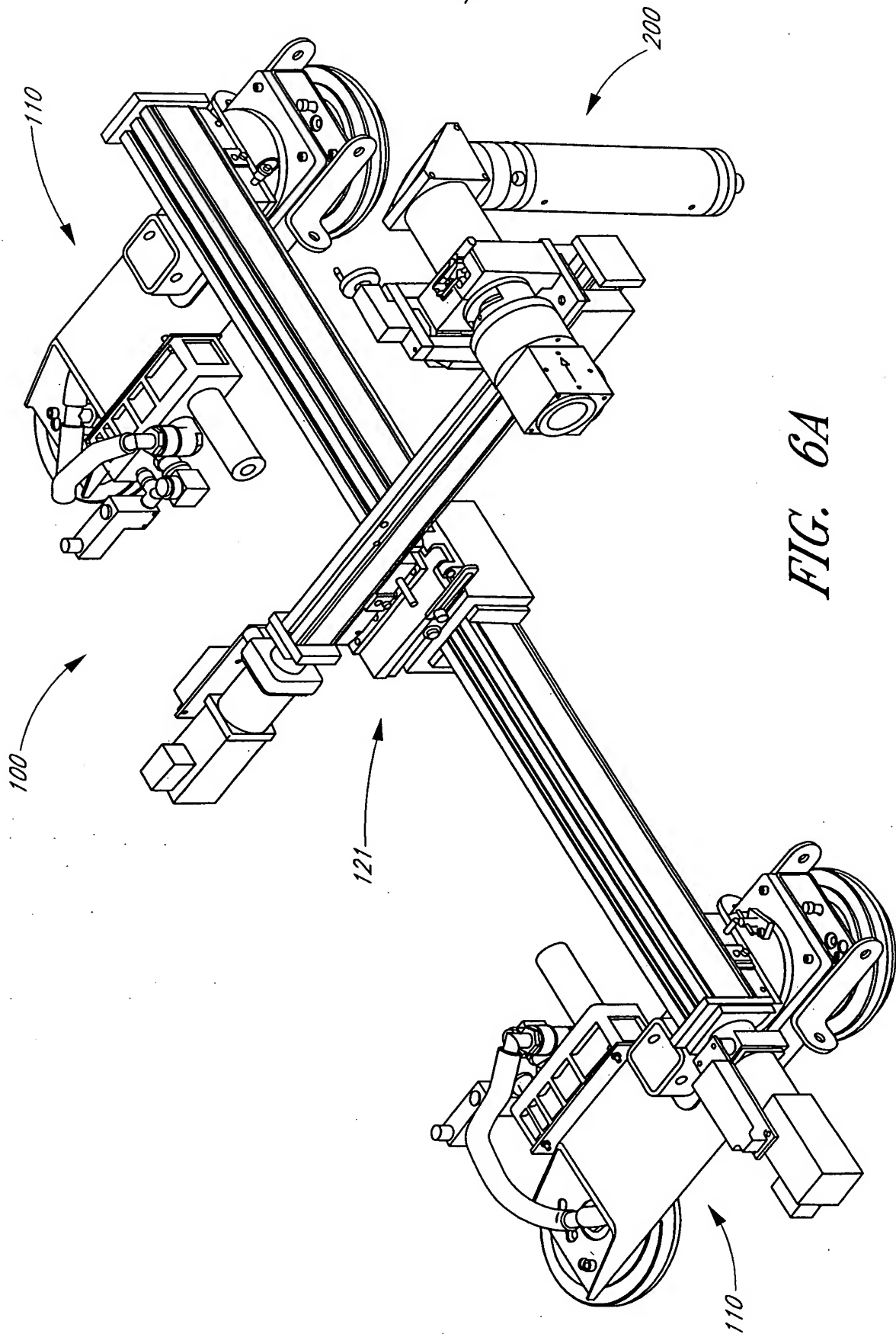


FIG. 6A

9/31

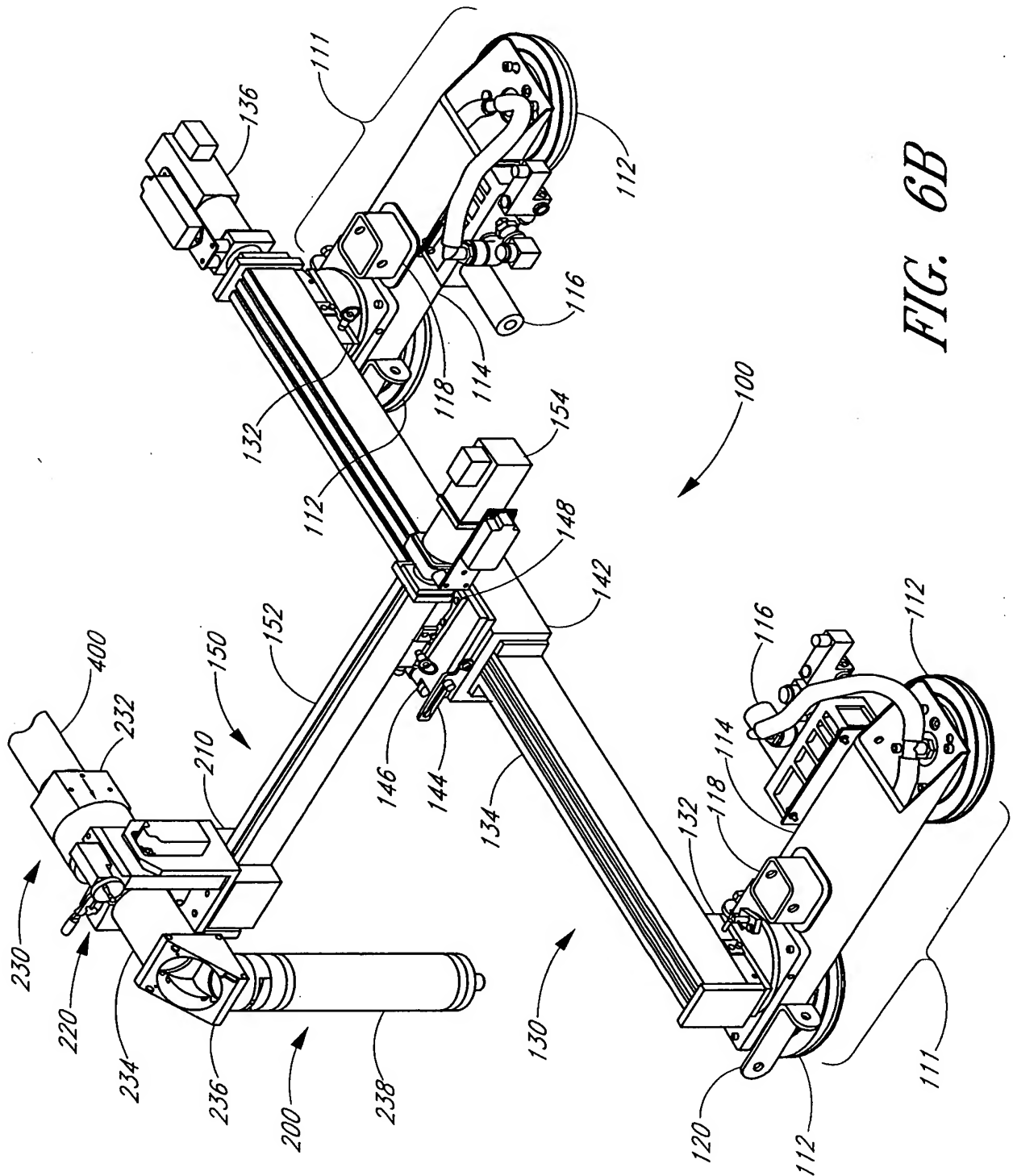


FIG. 6B

10/31

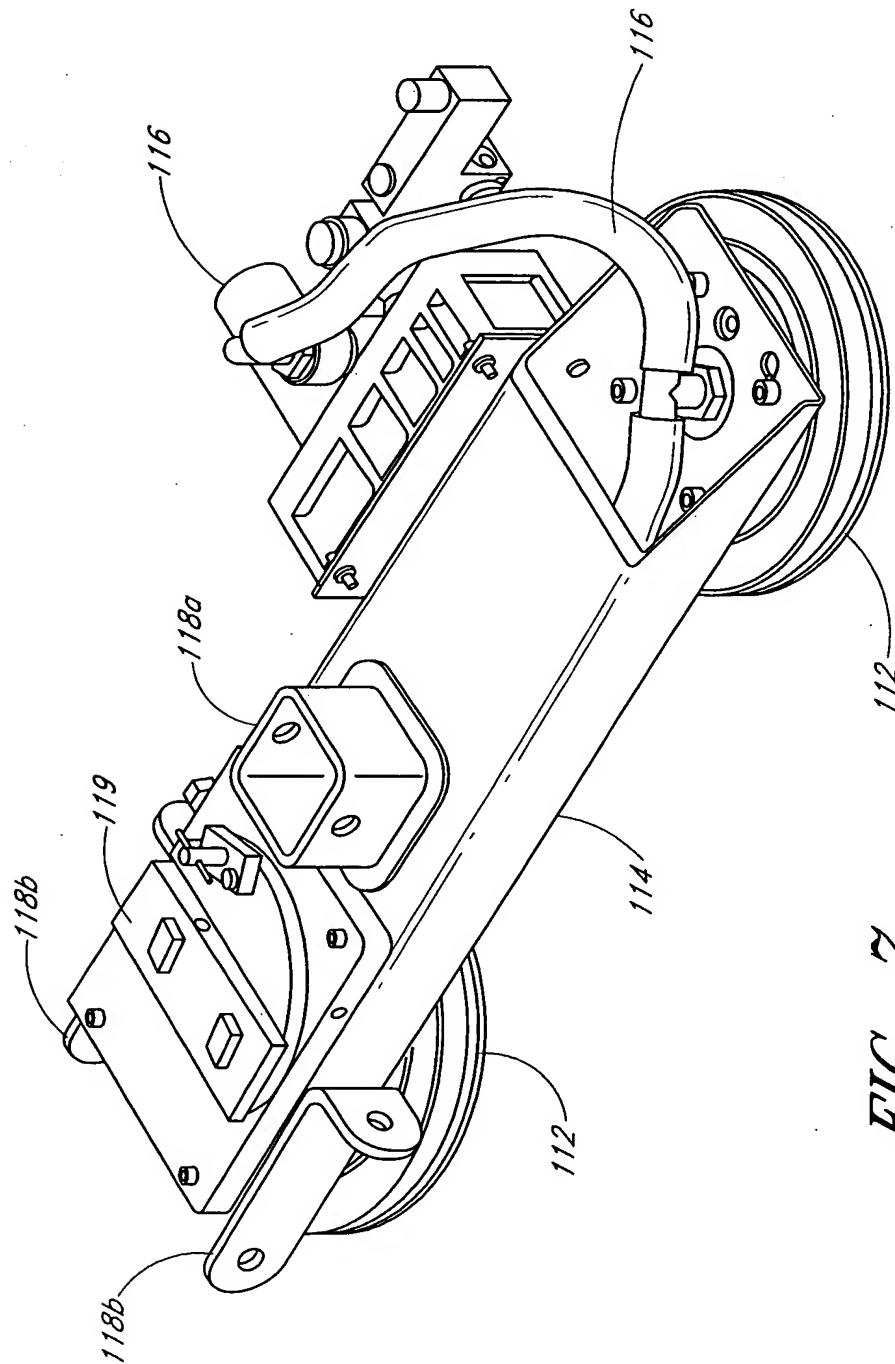
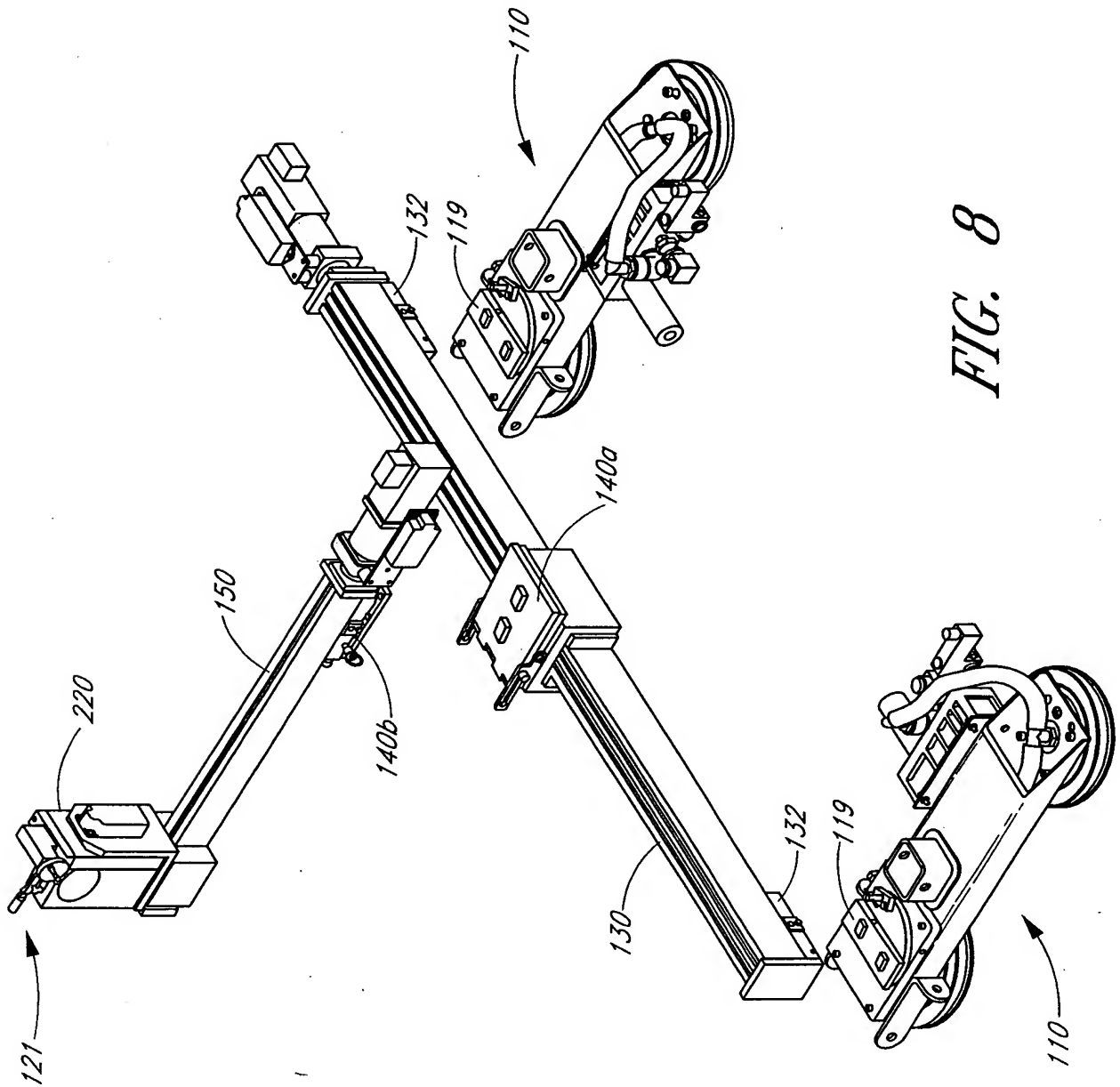


FIG. 7

11/31



12/31

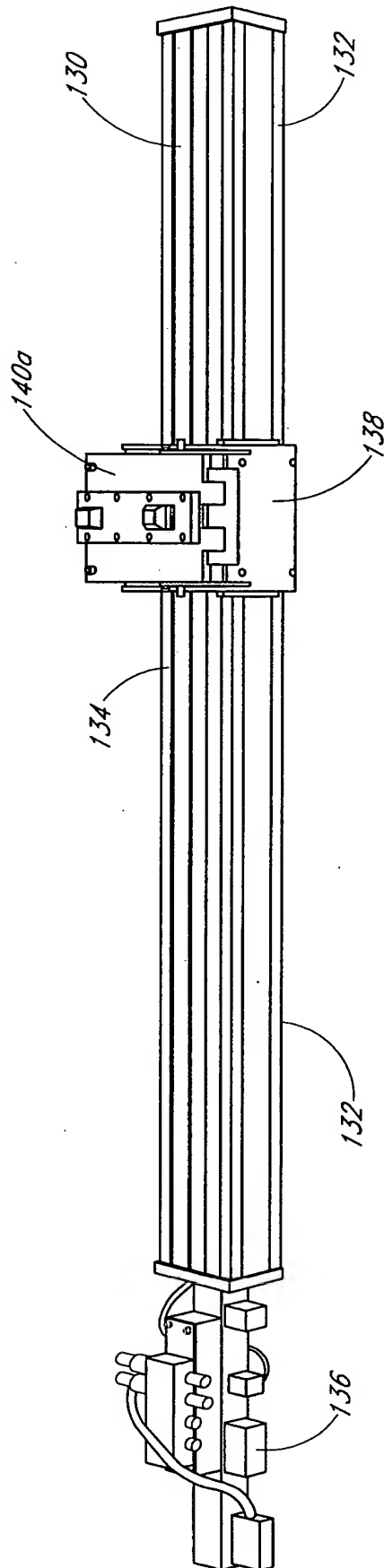


FIG. 9

13/31

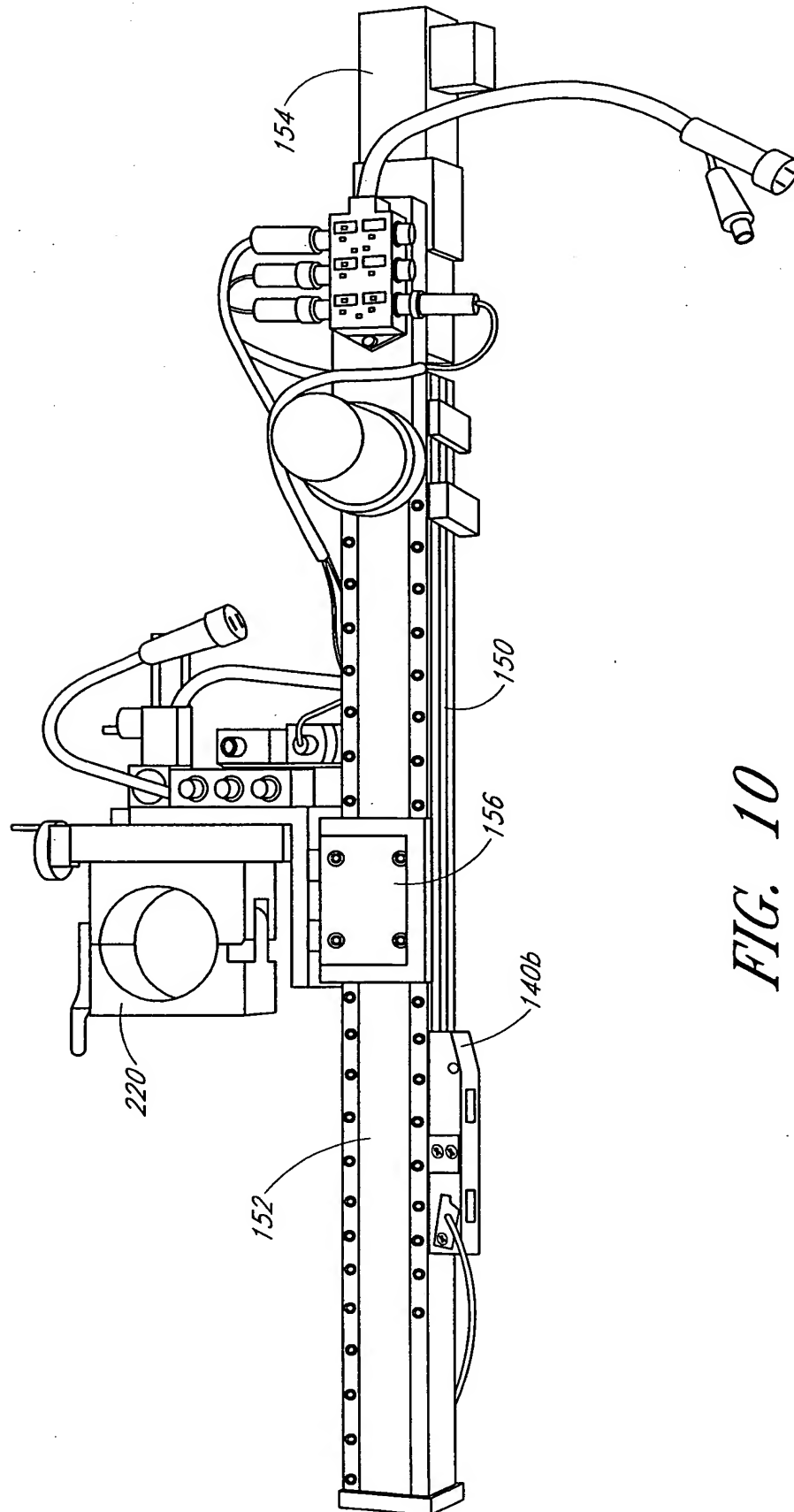
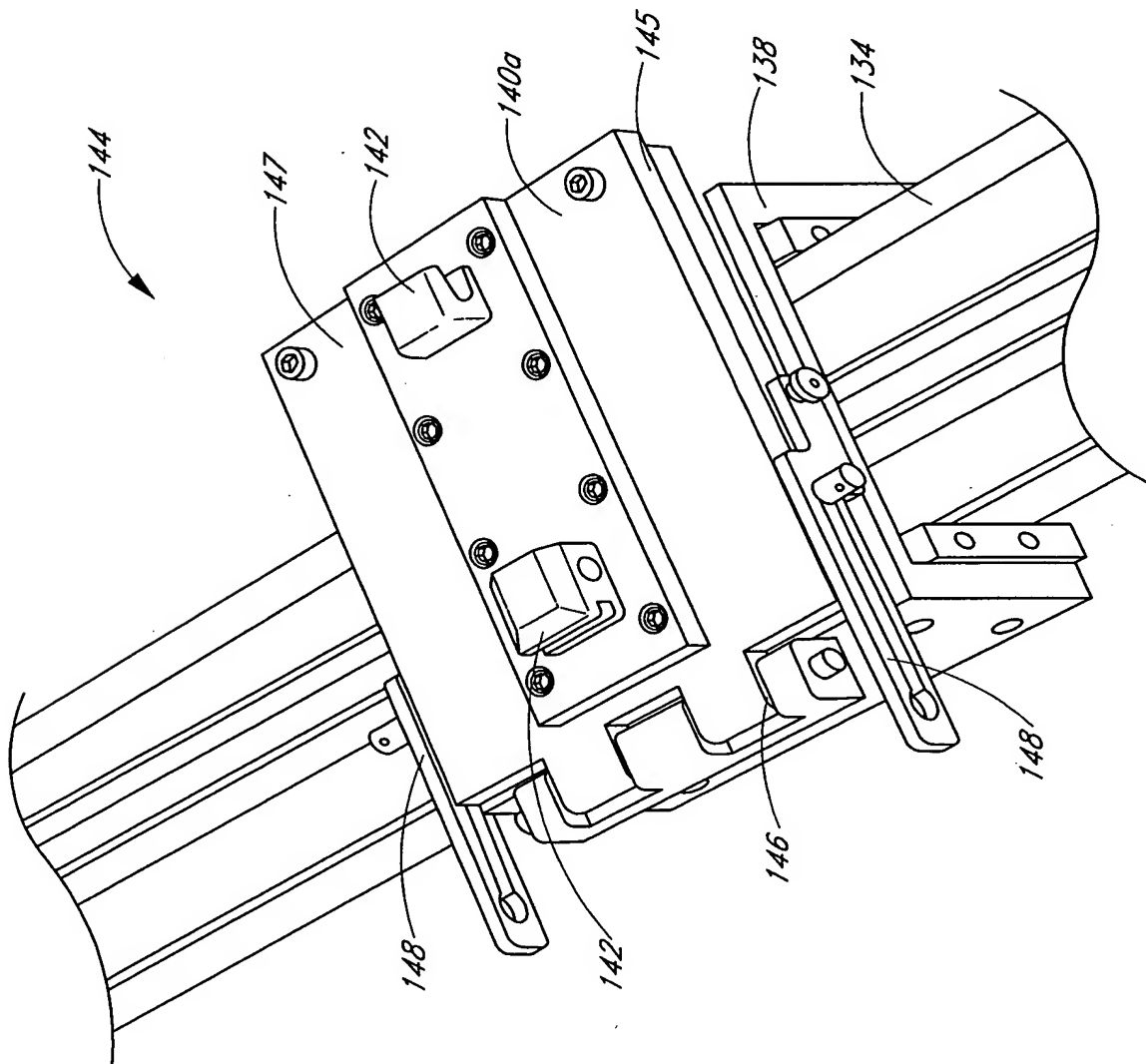


FIG. 10

FIG. 11A



15/31

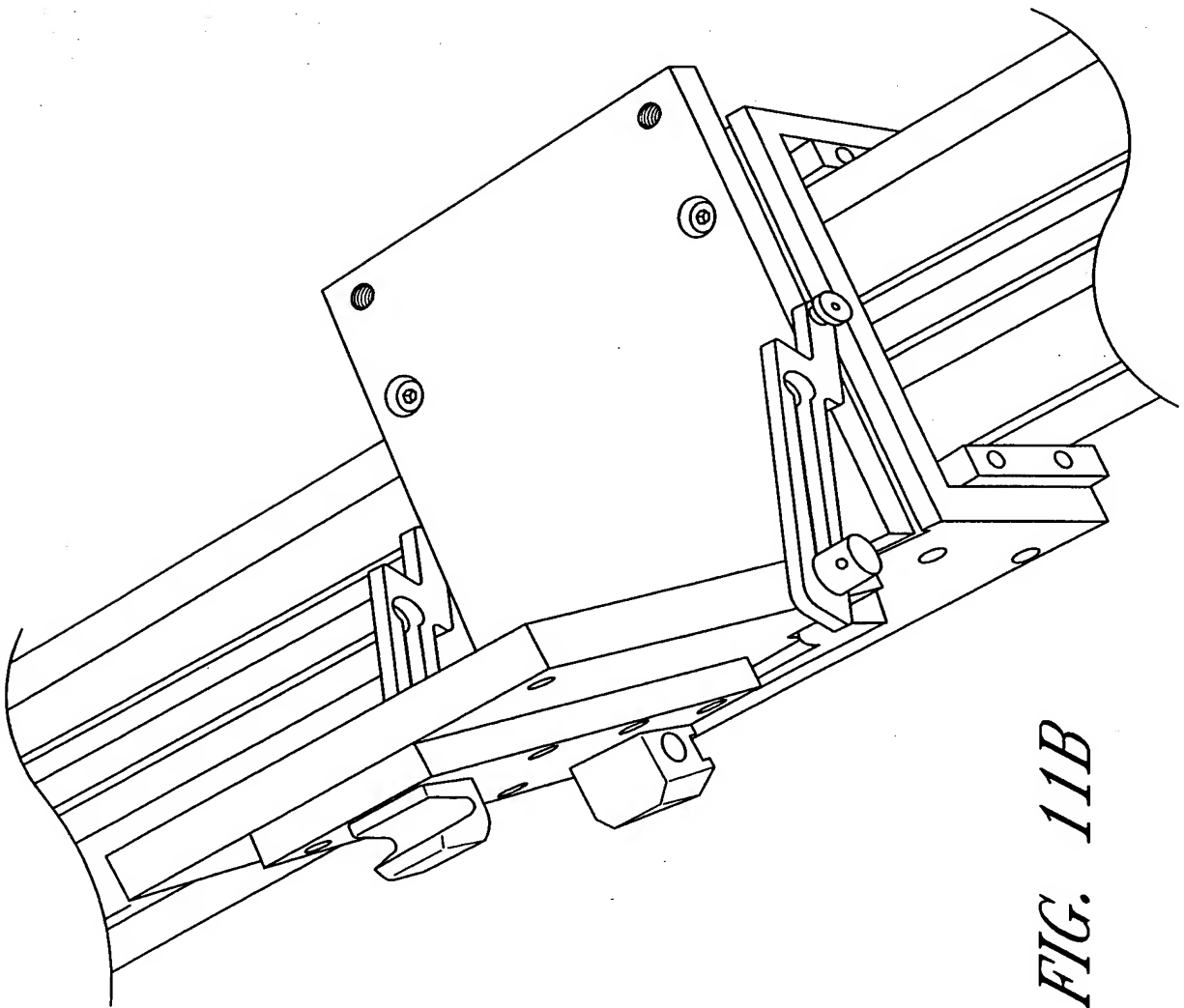


FIG. 11B

16/31

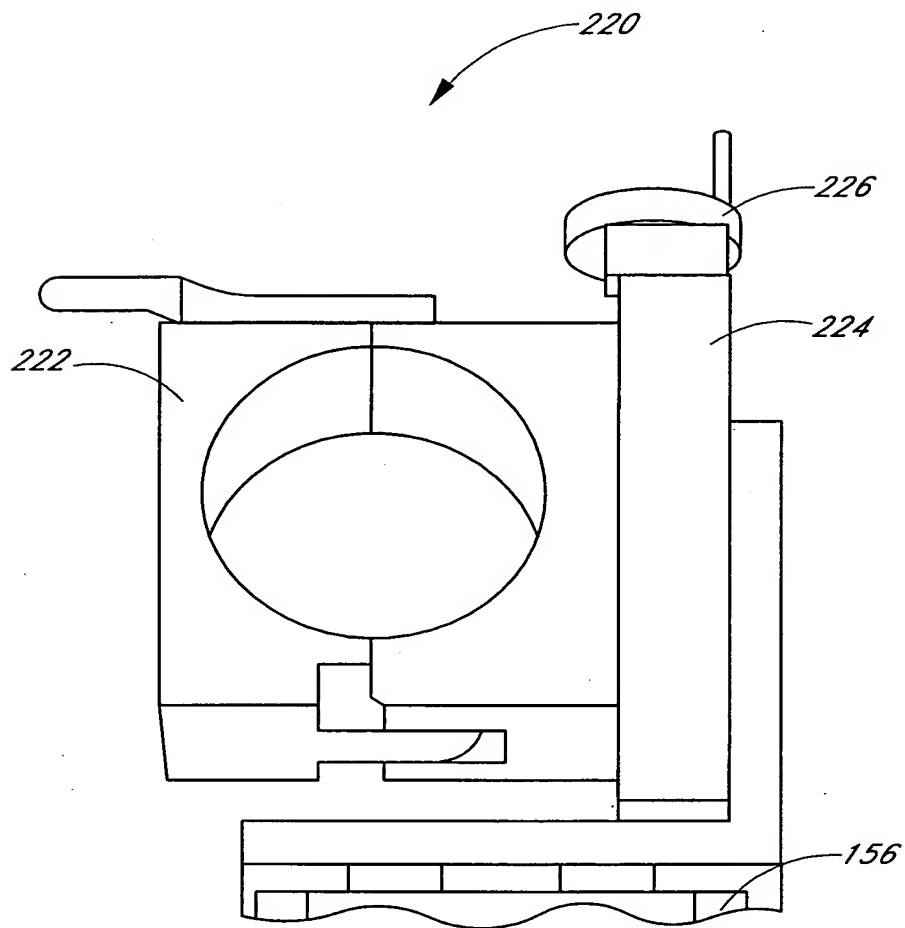


FIG. 12

17/31

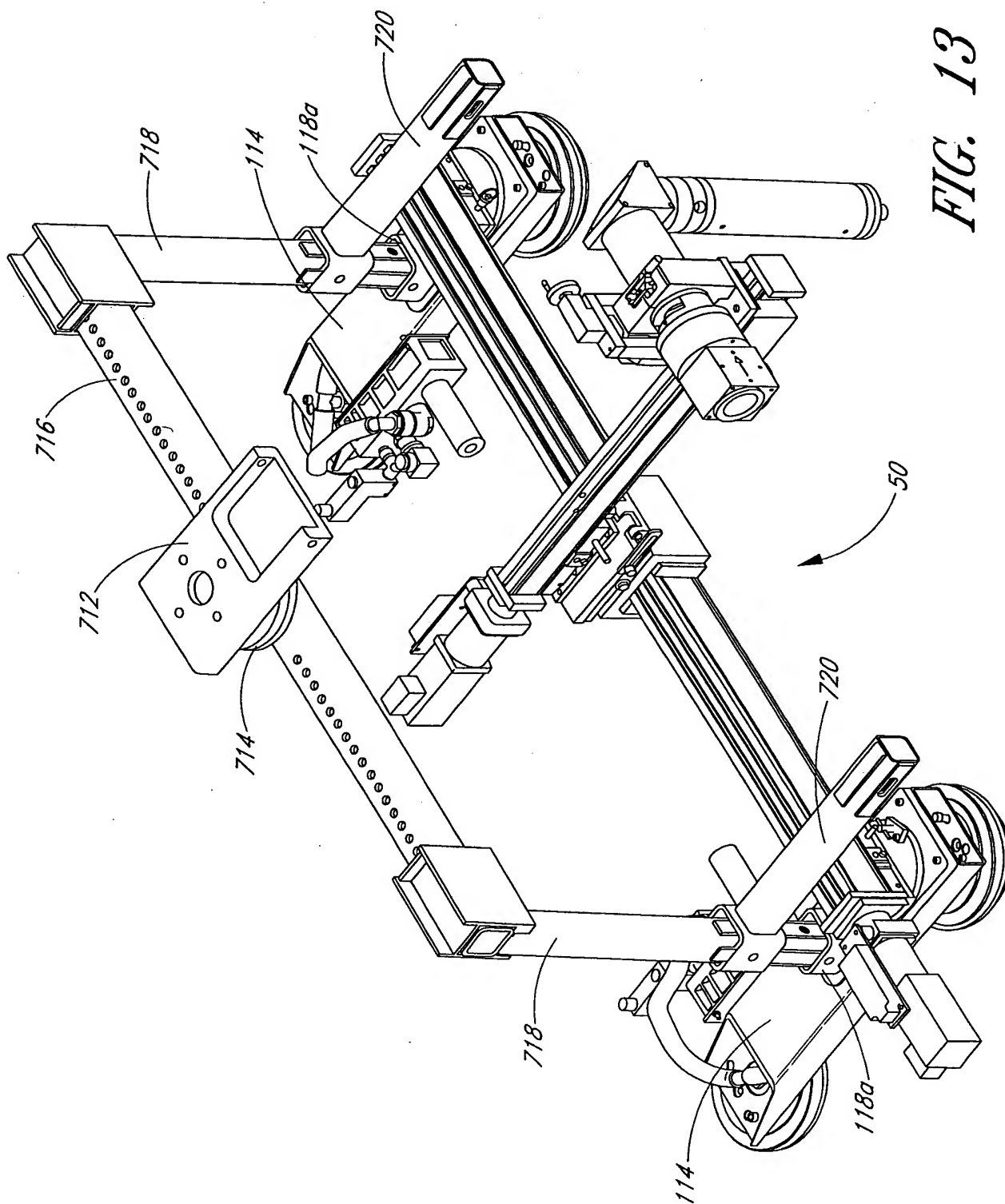


FIG. 13

18/31

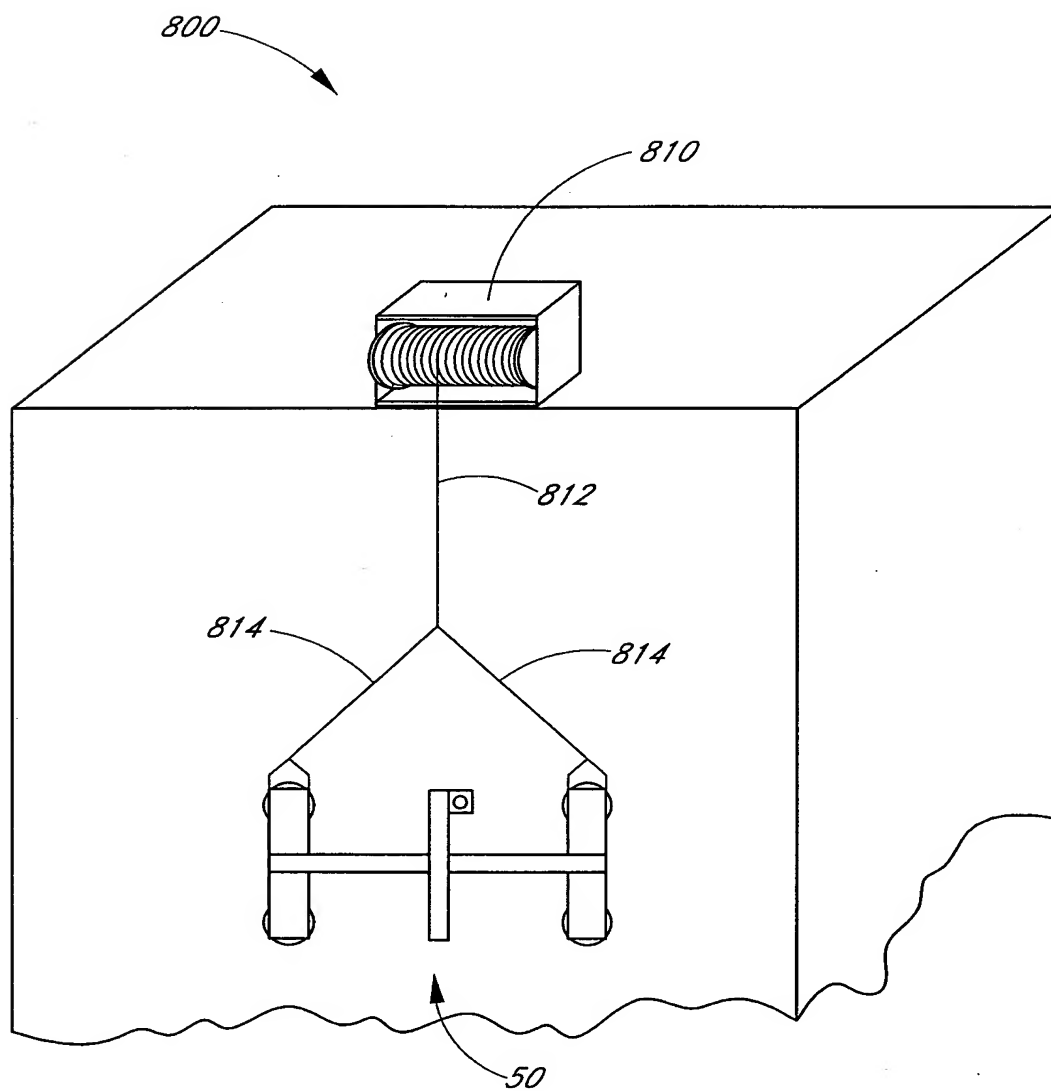


FIG. 14A

19/31

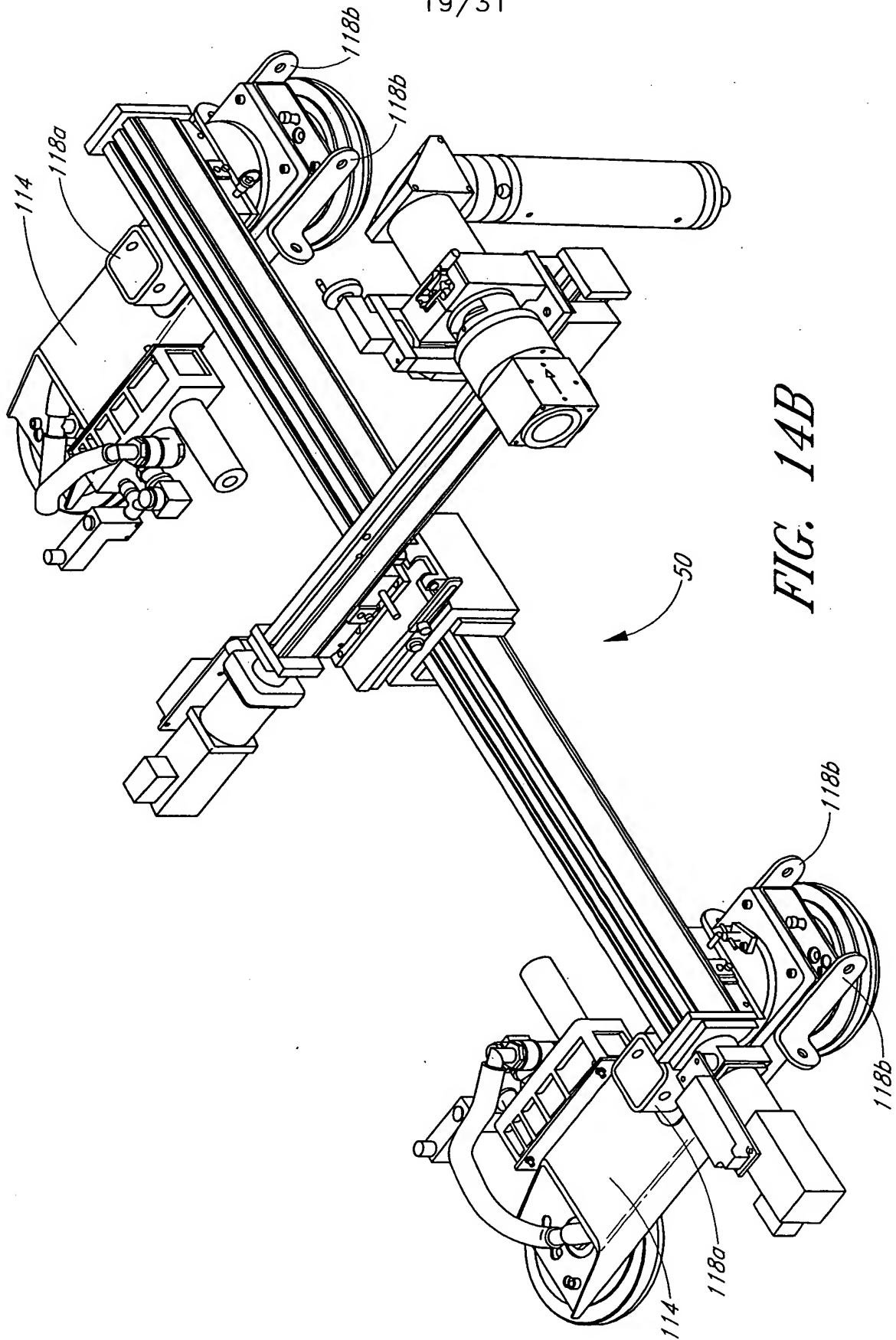


FIG. 14B

20/31

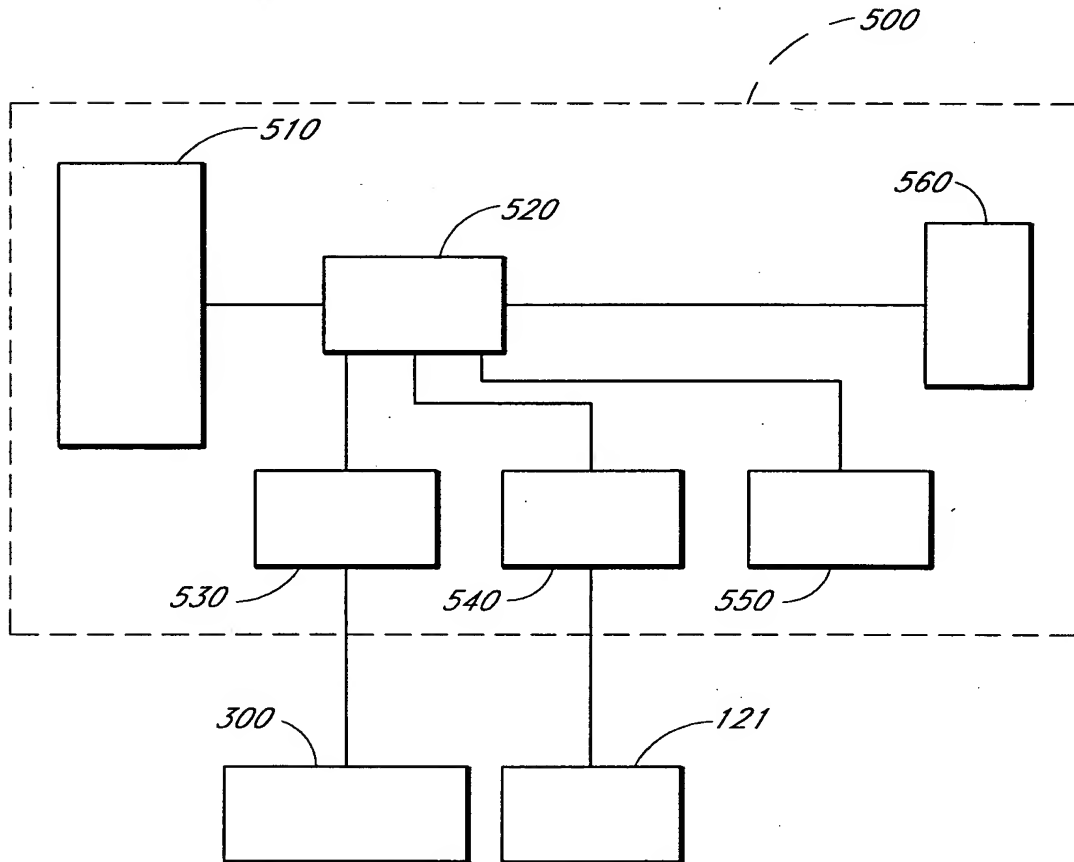


FIG. 15

21/31

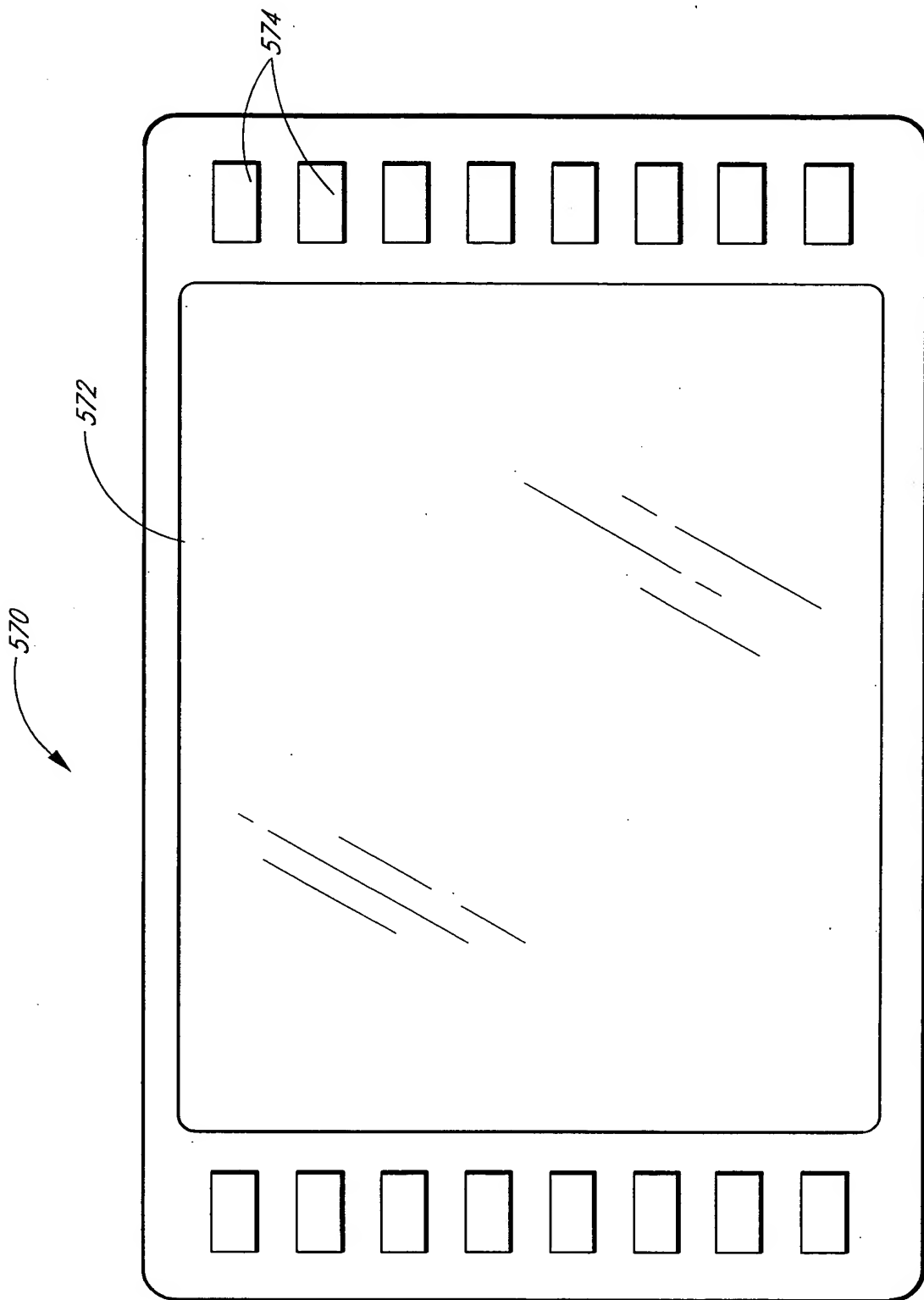


FIG. 16

22/31

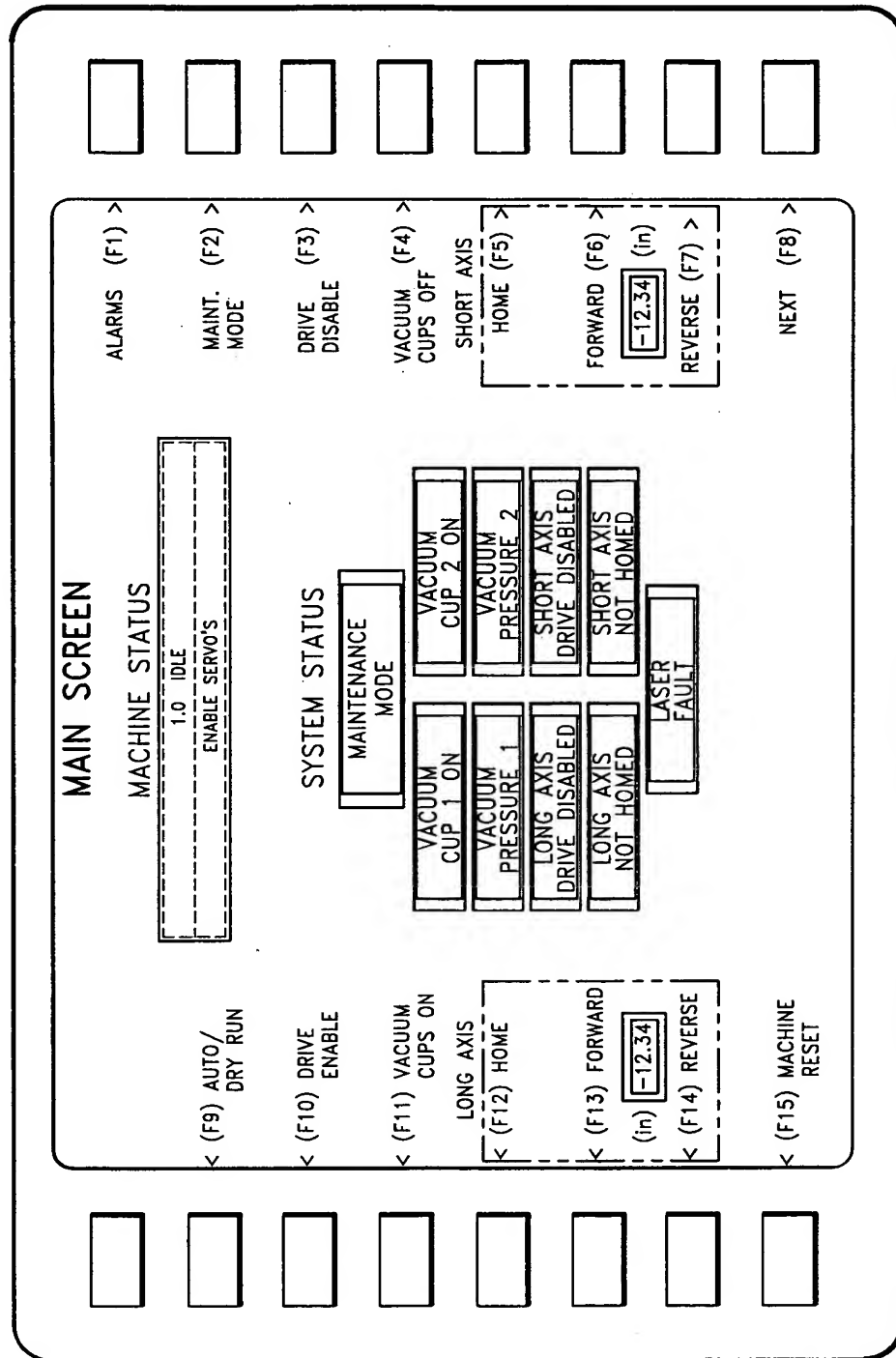


FIG. 17A

23/31

SELECT OPERATION SCREEN

MACHINE STATUS		SYSTEM STATUS		SHORT AXIS POSITION
< (F9) AUTO/ DRY RUN	1.0 IDLE ENABLE SERVO'S	MAINTENANCE MODE	CIRCLE IDLE	-12.34 (in)
< (F11) CIRCLE		PIERCE IDLE	STRAIGHT CUT IDLE	
< (F12) PIERCE			SURFACE KEYING IDLE	
< (F13) STRAIGHT CUT				
< (F14) SURFACE KEYING				
< (F15) MACHINE RESET				

LONG AXIS POSITION -12.34 (in)

NEXT (F8) >

FIG. 17B

CIRCLE SETUP/OPERATION SCREEN

MACHINE STATUS

1.0 IDLE
ENABLE SERVO'S

CIRCLE STATUS

2.0 CIRCLE SEQUENCE IDLE
PRESS CYCLE START TO BEGIN

SYSTEM STATUS

MAINTENANCE
MODE

SHORT AXIS
POSITION

-12.34 (in)

LONG AXIS
POSITION

-12.34 (in)

CYCLE (F4) >
STOP

CIRCLE PARAMETERS

REVOLUTIONS

STATUS 1234
SET POINT 1234
COUNT 123

DIAMETER (in)

STATUS -1.234
SET POINT -1.234

TIME (sec)

STATUS 1234
SET POINT 1234

LBU
PROGRAM NUMBER

STATUS 12
SET POINT 12

SPEED (in/min)

STATUS -12.34
SET POINT -12.34

< (F9) AUTO/
DRY RUN

< (F11) CYCLE
START

< (F15) MACHINE
RESET

NEXT (F8) >

FIG. 17C



FIG. 17D

26/31

CUT SETUP/OPERATION SCREEN

MACHINE STATUS

1.0 IDLE
ENABLE SERVO'S

CUT STATUS

4.0 CUT SEQUENCE IDLE
PRESS CYCLE START TO BEGIN

SYSTEM STATUS

MAINTENANCE
MODE

LONG AXIS POSITION

-12.34 (in)

SHORT AXIS POSITION

-12.34 (in)

SPEED (in/min)

STATUS -12.34
SET POINT -12.34

LENGTH (in)

STATUS -12.34
SET POINT -12.34

LONG AXIS

LONG AXIS
NOT SELECTED

SHORT AXIS

SHORT AXIS
NOT SELECTED

PROGRAM NUMBER

STATUS 12
SET POINT 12

LBU

CYCLE START

CYCLE STOP

MACHINE RESET

NEXT

FIG. 17E

27/31

SURFACE KEYING SETUP/OPERATION SCREEN

MACHINE STATUS

1.0 IDLE
 ENABLE SERVO'S

SURFACE KEYING STATUS

5.0 KEYING SEQUENCE IDLE
 PRESS CYCLE START TO BEGIN

SYSTEM STATUS

MAINTENANCE
 MODE

LONG AXIS POSITION

[-12.34] (in)

SHORT AXIS POSITION

[-12.34] (in)

SURFACE KEYING PARAMETERS

PROGRAM NUMBER

STATUS 12
 SET POINT 12

SHORT AXIS LENGTH (in)

STATUS [-12.34]
 SET POINT [-12.34]

LONG AXIS LENGTH (in)

STATUS [-12.34]
 SET POINT [-12.34]

SPEED (in/min)

STATUS [-12.34]
 SET POINT [-12.34]

OFFSET (in)

STATUS [-12.34]
 SET POINT [-12.34]

NEXT (F8) >

< (F9) AUTO/ DRY RUN

< (F11) CYCLE START

< (F15) MACHINE RESET

CYCLE (F4) >

FIG. 17F

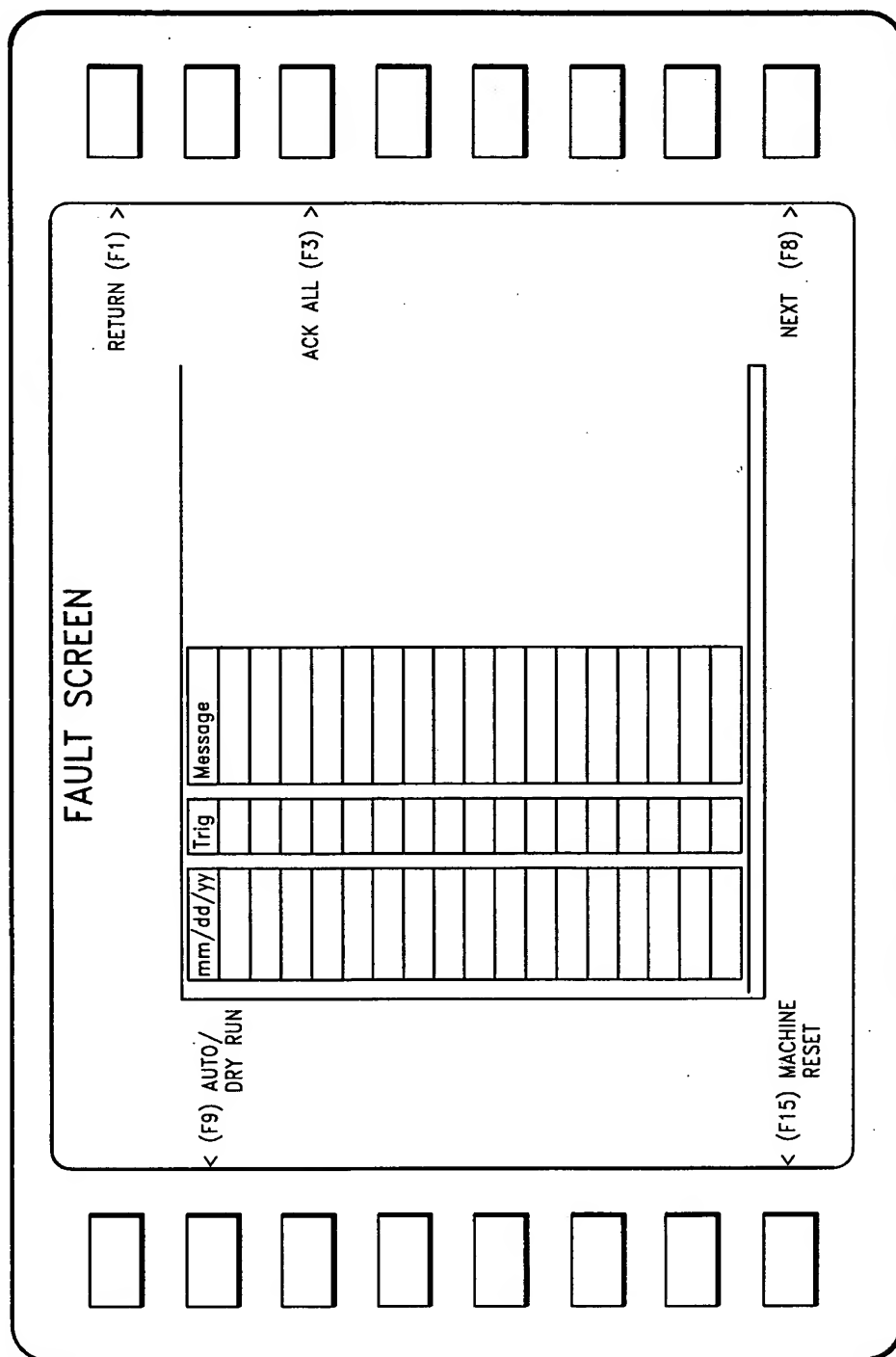


FIG. 17G

29/31

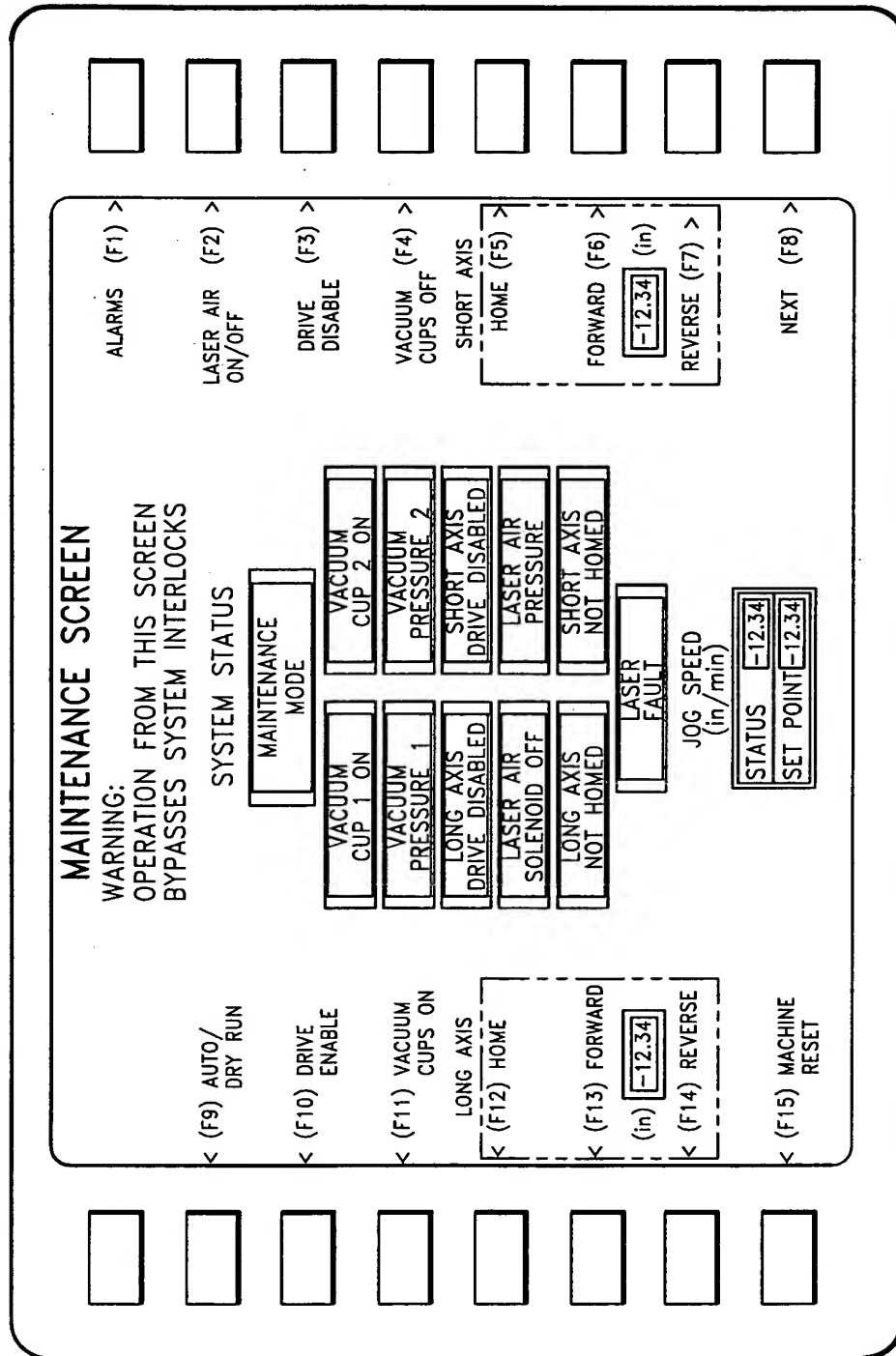


FIG. 17H

30/31

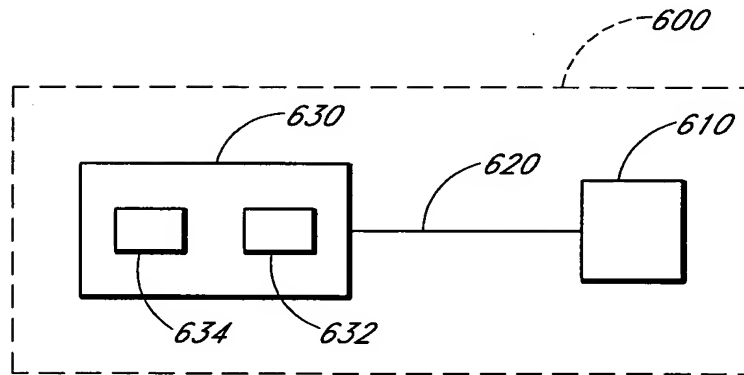


FIG. 18

31/31

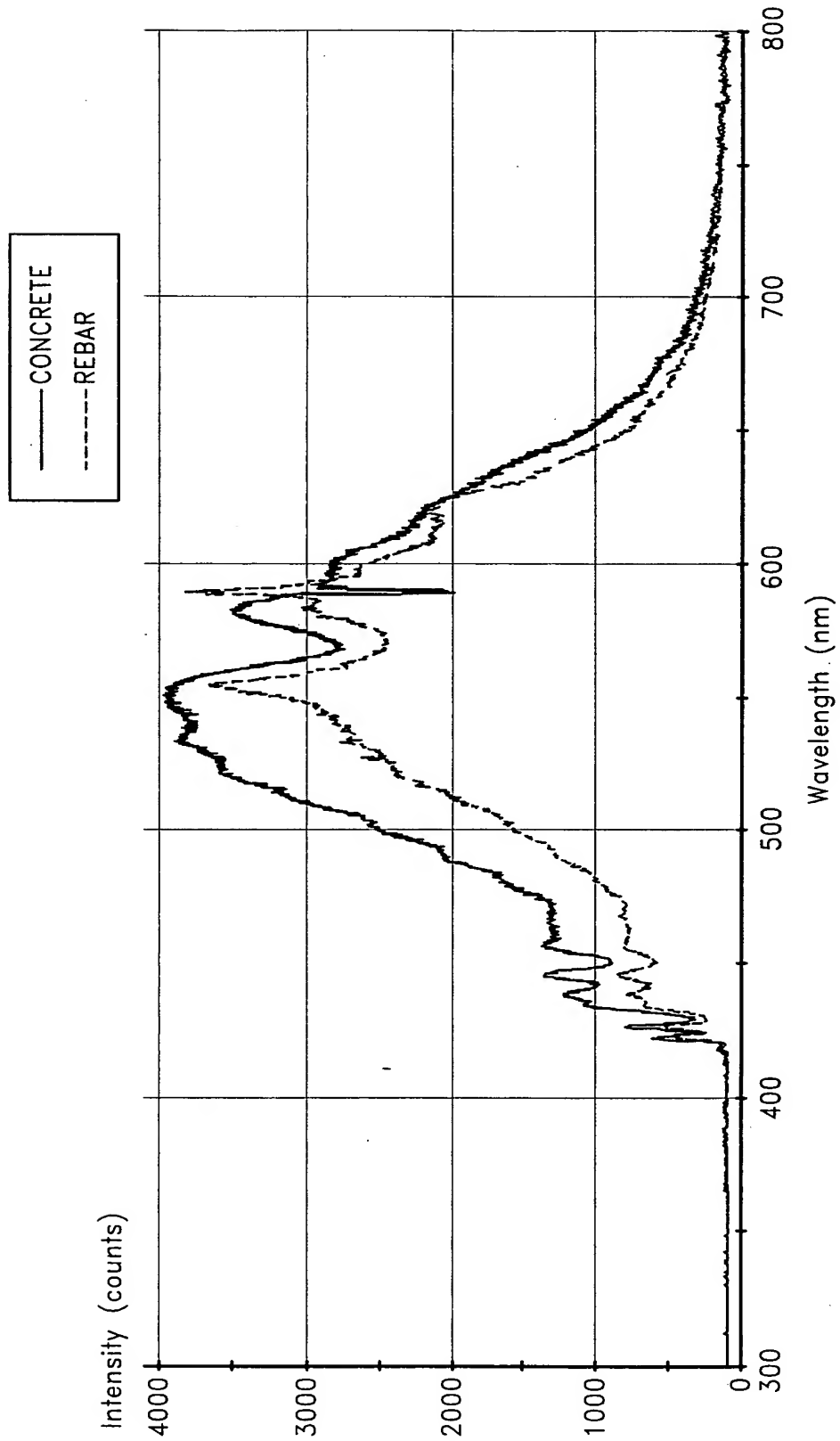


FIG. 19